

Date: Friday, 09/01/2009 11:03:23 AM
 User: Julie Dawson

Process Sheet

Split

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 44525 -2
 Estimate Number : 13184
 P.O. Number :
 This Issue : 09/01/2009 S.O. No. :
 Prsht Rev. : NC
 First Issue : 1/1 Type : MACHINED PARTS
 Previous Run : 38479
 Written By :
 Checked & Approved By : Julie Dawson
 Comment : Est Rev:A new issue 08-02-12 DD verified by:LL
 Est Rev:B As per Rev B 09-01-07 JLM Verified By:EC

Drawing Name : BIPOD MOUNT ASS'Y
 Part Number : D3685041
 Drawing Number : D3685 REV B
 Project Number : N/A
 Drawing Revision : B
 Material :
 Due Date : 26/01/2009 Qty: 1 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

2.0 D36873 MOUNT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

MOUNT

batch D44684

EB 09/04/16

3.0 D3684047 FWD LEG ASS'Y



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

FWD LEG ASS'Y

batch D44631

9/4/27

SV

4.0 D3684049 AFT LEG ASS'Y



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

AFT LEG ASS'Y

batch D44631

9/4/27

SV

5.0 D36921 SPACER



Comment: Qty.: 8.0000 Each(s)/Unit Total : 40.0000 Each(s)

SPACER

batch B46053

EB 09/04/16

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BIPOD MOUNT ASSY

Job Number: 44525

Part Number: D3685041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

AN3C12A

Bolts



Comment: Qty.: 4.0000 Each(s)/Unit Total: 20.0000 Each(s)

Bolts

batch

M110155

(8+)

M1101552

(8L)

Epo9/04/16

7.0

MS210433

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total: 20.0000 Each(s)

Nut

batch

M111041

Epo9/04/16

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: 1-Use anti-seize compound on thread and assemble as per dwg D3684

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S0908/04

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with Dart part # using a fine point permanent marker and Stock
Location: _____

9/8/04

SP (K)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

P09.12

Job Completion



u 9.8.04

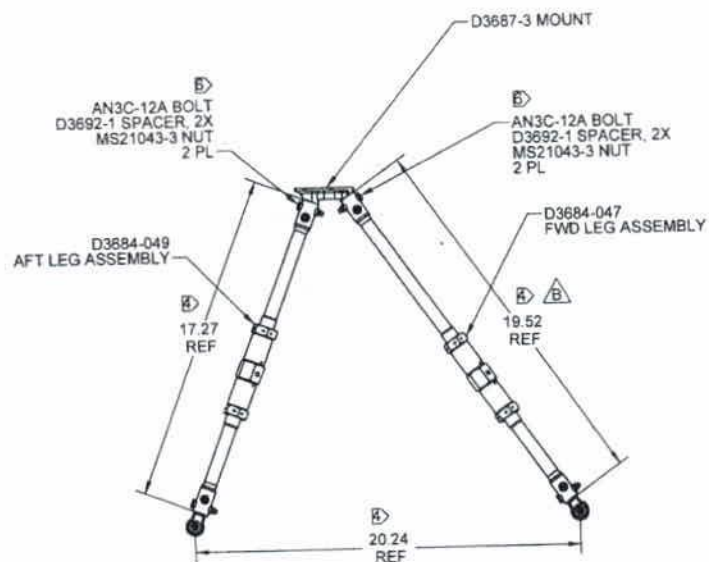
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: D3685-041 PAR #: _____ Fault Category: Sm FAB NCR: Yes No DQA: ✓ Date: 09.08.12
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: ✓ Date: 05.05.17

| NCR: <u>44525</u> | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|-------------------|---|--|-----------------------------|--|------------------------------|-----------------------------|-----------------------------|-----------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| <u>9/8/14</u> | <u>#1</u> <u>Small</u> <u>FAB</u> | <u>Decline Assembly of D3685-041</u> <u>The employee found that D3687-3</u> <u>was to have to install in the</u> <u>D3684-047. He was trying to</u> | <u>✓</u> <u>09/08/14</u> | <u>Scrap D3688-3 stud and</u> <u>replace on this into</u> <u>BA <u>45671</u></u> | <u>EB</u> <u>09/08/14</u> | <u>S</u> <u>09/08/14</u> | <u>✓</u> <u>09/08/14</u> | <u>S</u> <u>09/08/14</u> |
| | | <u>Remove she placed D3684-047</u> <u>in a vise on a name that it was</u> <u>clamping on the threads of</u> <u>D3688-3 stud causing the threads</u> <u>to be squashed at the top of the</u> <u>threads.</u> | <u>✓</u> <u>09/08/14</u> | <u>to inform employee when doing</u> <u>a new assembly basic question</u> <u>be for starting</u> | <u>EB</u> <u>09/08/14</u> | <u>S</u> <u>09/08/14</u> | <u>✓</u> <u>09/08/14</u> | <u>S</u> <u>09/08/14</u> |
| | | <u>P.C. interference in doing this</u> <u>assembly. L.O.A.</u> | <u>✓</u> <u>09/08/14</u> | <u>to fill out employee training</u> <u>sheet.</u> | <u>EB</u> <u>09/08/14</u> | <u>S</u> <u>09/08/14</u> | <u>✓</u> <u>09/08/14</u> | <u>S</u> <u>09/08/14</u> |

NOTE: Date & initial all entries

| ITEM | QTY -041 | PART NUMBER | DESCRIPTION |
|------|-------------|-------------|----------------------|
| 1 | X | D3685-041 | BIPOD MOUNT ASSEMBLY |
| 2 | 1 | D3687-3 | MOUNT |
| 3 | 1 | D3684-047 | FWD LEG ASSEMBLY |
| 4 | 1 | D3684-049 | AFT LEG ASSEMBLY |
| 5 | 8 | D3692-1 | SPACER |
| 6 | 4 | AN3C-12A | BOLT |
| 7 | 4 | MS21043-3 | NUT |



D3685-041 BIPOD MOUNT ASSEMBLY

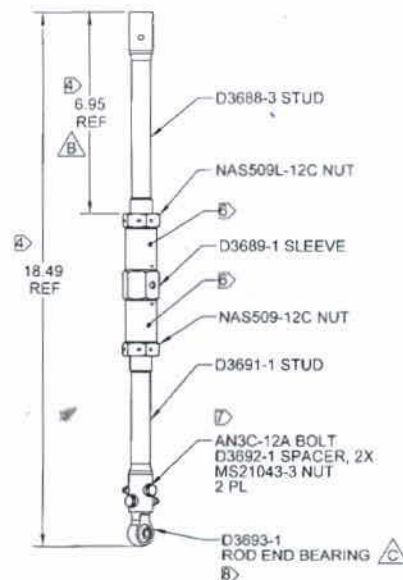
NOTES:

- 1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) UNITS: INCHES UNLESS OTHERWISE NOTED
- 3) IDENTIFICATION: IDENTIFY WITH DART ASSEMBLY P/N D3685-041 USING FINE POINT PERMANENT INK MARKER
- 4) DIMENSIONS SHOWN ARE WHEN D3688-1/3 & D3691-1 STUDS ARE FULLY THREADED INTO D3689-1 SLEEVES
- 5) WEIGHT: 6.6 lbs
- 6) TORQUE FASTENERS TO 20-25 in-lbs

RELEASED
08/12/15

| | | | |
|-----------|---|---|--------------|
| B | 19.52 WAS 19.95 (ZN B4-1); REFORMATTED TO CURRENT DWG STANDARDS | RF | 08.11.24 |
| A | NEW ISSUE | RF | 08.05.22 |
| REV | DESCRIPTION | BY | DATE |
| DESIGN | RF | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | RF | | |
| CHECKED | RF | DRAWING NO. | REV: B |
| MFG. APPR | RF | D3685 | SHEET 1 OF 1 |
| APPROVED | RF | TITLE | SCALE |
| DE APPR | RF | BIPOD MOUNT ASSEMBLY | NTS |
| DATE | 08.11.24 | <small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISCLOSED OR REPRODUCED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.</small> | |

| ITEM | QTY 049 | PART NUMBER | DESCRIPTION |
|------|------------|-------------|------------------|
| 1 | X | D3684-049 | AFT LEG ASSEMBLY |
| 2 | 1 | D3688-3 | STUD |
| 3 | 1 | D3689-1 | SLEEVE |
| 4 | 1 | D3691-1 | STUD |
| 5 | 4 | D3692-1 | SPACER |
| 6 | 1 | D3693-1 | ROD END BEARING |
| 7 | 2 | AN3C-12A | BOLT |
| 8 | 2 | MS21043-3 | NUT |
| 9 | 1 | NAS509L-12C | NUT |
| 10 | 1 | NAS509-12C | NUT |



D3684-049 AFT LEG ASSEMBLY

44525

RELEASED
09/01/12

NOTES:

- 1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) UNITS: INCHES UNLESS OTHERWISE NOTED
- 3) IDENTIFICATION: NONE
- 4) DIMENSION SHOWN IS WHEN D3688-3 & D3691-1 STUDS ARE FULLY THREADED INTO D3689-1 SLEEVE
- 5) WEIGHT: 2.88 lbs
- 6) USE TECTYL 502C CLASS I, MIL-PRF-16173E GRADE 2 OR EQUIVALENT ANTI-SEIZE COMPOUND ON THREAD
- 7) TORQUE FASTENERS TO 20-25 in-lbs
- 8) ASSEMBLE D3693-1 WITH D3691-1 USING SIKAFLEX-2411-291 OR PROSEAL 890 OR MIL-S-8802 CLASS 'B2' SEALANT BETWEEN MATING SURFACES. ENSURE HOLES FOR AN3C BOLTS ARE CLEAR OF SEALANT

| | | | |
|------------|----------|--|--------------|
| DESIGN | RF | DART AEROSPACE LTD | |
| DRAWN | RF | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. | REV. C |
| MFG. APPR. | | D3684 | SHEET 5 OF 5 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | TRIPOD MOUNT ASSY | NTS |
| DATE | 08.12.15 | COPYRIGHT © 2008 BY DART AEROSPACE LTD | |

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries